

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019111**Date Inspected:** 07-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of critical repair (R3) weld is identified as 3G-005 of SB022-104 for SB104 West. The welder is identified as 058792. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair and CWR-02693.

SMAW welding of repair (R2) weld is identified as 1G-002 of SB023-106 for SB106 East. The welder is identified as 067520. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G-Repair and WR-19884.

FCAW welding of weld is identified as 2G-007 of BK004B6-001 for BK004B-001. The welder is identified as 062806. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

FCAW welding of weld is identified as 3G-165 of BK005A6-002 for BK005A-002. The welder is identified as 062749. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

ZPMC personnel performing Fit-up of end closure box cover plate is in progress.

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OUTSIDE YARD

This QA inspector performed MT 15% base metal repair locations areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK4A-012

BK4A-009

BK4A-003

BK4A-008

BK4A-008

BK4A-004

This QA inspector performed internal cleaning and greasing on anchor house cover verified with ZPMC QC Mr.Xu tao is appeared to comply with the documents. The bike path is identified as BK004A-001,003,004,005,009,008,010,012.
BK006A-002.

Following bike paths the internal greasing was not applied properly informed to ZPMC QA Mr. Wang lu.
BK004A-020,021,053,054.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer